

Table V

Draw-Texturing Conditions and Textured Yarn Properties

Example Id.	Draw Ratio ¹	Heater Temp, °C	Take-up Speed ² (M/M)	Disc Config ³	Disc to Yarn Ratio ⁴	Tension ⁵ , g/d (dN/tex)	Final Denier (dtex)	Final Tenacity, g/d (dN/tex)	Final E _B , %	Leesona Shrinkage
IV-A	1.509	180	500	1/3/1	1.95	35(31)	162(180)	2.88(2.54)	43.8	47.7
comp. A	1.710	225	500	1/5/1	1.95	65(57)	163(181)	4.46(3.94)	20.2	42.04
IV-B	1.539	180	450	1/3/1	1.95	32(28)	159(177)	2.50(2.21)	37.1	31.6
comp. B	1.647	220	600	1/5/1	1.95	34(30)	156(173)	4.06(3.58)	23.8	33.8
IV-C	1.539	180	500	1/3/1	1.95	27(24)	72(80)	2.90(2.56)	46.2	48.9
comp. C	1.710	210	600	1/5/1	1.95	20(18)	73(81)	4.81(4.25)	23.2	50.5
IV-D	1.464	180	400	1/4/1	1.95	27(24)	72(80)	2.86(2.52)	46.2	16.05
comp. D	1.560	200	500	1/7/1	1.95	20(18)	74(82)	4.39(3.87)	39.3	13.35
IV-E	1.495	180	400	1/4/1	2.1	33(29)	151(168)	2.80(2.47)	39.0	10.25
comp. E	1.590	200	500	1/7/1	2.1	20(18)	160(178)	3.80(3.35)	43.7	9.30
IV-F	1.470	180	400	1/4/1	1.95	28(25)	78(87)	3.15(2.78)	34.9	30.6

1 - S₂/S₁; 2 - S₃; 3 - Entry guide discs/Working discs/Exit guide discs; 4 - S₄/Y_s; 5 - Measured at tension monitor 63